

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018618**Date Inspected:** 13-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Trial assembly yard, 12AW, X74C, X74D to X37L.

SMAW welding of weld joint SEG3004N-001, 002; located at Trial assembly yard. Welder is identified as 045268; ZPMC Quality Control Inspector (QC) is identified as Zhang Qiang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2112, WPS-B-P-2113, WPS-B-P-2114. The attached photographs provide additional detail

Trial assembly yard, Connection Splice plates.

SMAW Repair welding (Ultrasonic Inspection repair per ZPMC UT-report # B787-UT-16496) of weld joint USPL1-655-001 (WRR # B-WR19044); located at Trial assembly yard. Welder is identified as 046709; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-1G(1F)-FCM-REPAIR-1. The attached photographs provide additional detail.

Trial assembly yard, Connection Splice plates.

During Random Visual in process Inspection, this QA inspector observed Repair excavation of the weld on connection splice plate identified as USPL1-654-002. Carbon-Air-Arc gouging was used for excavation. Excavation was being done according to ZPMC Ultrasonic Inspection (UT) report # B787-UT-16496. Quality Control Inspector (QC) is identified as Zhu Peng. The attached photographs provide additional detail.

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This QA Inspector carried out NDE on following
Trial assembly yard, CB18.

This QA Inspector performed a random visual inspection on this crossbeam; this QA marked the areas of visual weld defects that will require welding. This QA marked the affected areas and informed ZPMC Quality Control (QC) indentified as Mr. Zheng zhi wei of this issue. Mr. Zheng zhi wei informed this QA that the weld defects would be corrected in a manner compliant with the contract documents.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

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Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Dsouza,Christopher	QA Reviewer
